

Amendments to the Claims:

This listing of claims will replace all prior versions and listings of claims in the application.

Listing of Claims:

1. (original) A method for installing a head stack assembly into a basedeck assembly to form a head disc assembly of a disc drive, comprising steps of:
 - (a) directing a robotic arm to pick and place the head stack assembly into the basedeck assembly;
 - (b) determining compliance of mechanical resistance encountered as the head stack assembly engages the basedeck in relation to installation force magnitude and rate of change of installation force magnitude, over time and position;
 - (c) seating the head stack assembly onto the basedeck assembly forming the head disc assembly, upon determining mechanical resistance and slope compliance; and
 - (d) releasing the head disc assembly from the head stack installation station.
2. (original) The method of claim 1, in which steps (a) through (e) are executed and controlled by an installation software program having installation steps stored on a recordable medium.
3. (original) The method of claim 2, in which the directing step (a) comprises:
 - (a1) compelling a central processing unit of a computer communicating with a head stack installation tool to read a volatile memory until both a head stack present signal and a basedeck present signal are read and reporting presence

of the head stack assembly and the basedeck assembly to the installation software program;

(a2) acquiring and reporting a head stack assembly serial number and a head disc assembly serial number to the installation software program;

(a3) querying a head stack assembly data base for physical characteristics of the head stack assembly and a head disc assembly data base for physical characteristics of the head disc assembly; and

(a4) comparing the compatibility between the physical characteristics of the head disc assembly and the physical characteristics of the head stack assembly.

4. (original) The method of claim 3 wherein the physical characteristics of the head disc assembly and the physical characteristics of the head stack assembly are compatible, and in which the directing step (a) further comprises:

(a5) reading position data of a horizontal slide and a vertical slide;

(a6) directing alignment of an end effector assembly adjacent the head stack assembly based on the horizontal slide and the vertical slide position data;

(a7) enjoining radial displacement of radially disposed positionable gripper sections and lineal movement of a pair of opposing positionable flex connector grippers to engage a beveled pick and place member and a flex connector body of the head stack assembly;

(a8) measuring the radial displacement of the radially disposed positionable gripper sections with a potentiometer.

5. (original) The method of claim 4 wherein the measurement of radial displacement of the radially disposed positionable gripper sections is consistent with the radially disposed positionable gripper sections engaging the beveled pick and place member of the head stack assembly, and in which the directing step (a) further comprises:

(a9) commanding removal of the head stack assembly from a nesting position of the head stack installation tool; and

(a10) directing alignment of the end effector assembly adjacent a head stack assembly post of the basedeck assembly.

6. (original) The method of claim 2 in which the determining step (b) comprises:

(b1) enjoining engagement of a tolerance ring supported by a head stack assembly post of the basedeck assembly;

(b2) dispatching the robotic assembly to commence pressing the head stack assembly onto the tolerance ring;

(b3) compelling a linear variable differential transformer to measure the distance traveled by the head stack assembly relative to the head stack assembly post and a load cell to measure an amount of mechanical resistance imparted on the head stack assembly; and

(b4) calculating the mechanical resistance encountered by the head stack assembly engaging the basedeck and the dynamic slope by dividing the difference in the measured distance traveled between two points along the installation path into the difference in mechanical resistance encountered by the head stack assembly between the same two points during the same period of time.

7. (previously presented) The method of claim 6 wherein the installation force magnitude is a dynamic force threshold F derived from a relation ($F = f(p) \pm (x)$), where $f(p)$ is a profile of force as a function of position and x is a scalar value, the rate of change of installation force magnitude is a dynamic slope V determined by a slope derived from a relation $V = (f_n - f_{n-1}) / (p_n - p_{n-1})$ at time (t_{n-1} and t_n), where f_n represents the mechanical resistance occurring at a point in time t_n while at a position of engagement p_n and f_{n-1} represents the mechanical resistance occurring at a preceding point in time t_{n-1} while at a preceding position of engagement p_{n-1} , and wherein the mechanical resistance encountered by the head stack assembly engaging the basedeck complies with the dynamic force threshold F and the dynamic slope V remaining compliant with predetermined values, in which the seating step (c) comprises:

- (c1) continuing pressing the head stack assembly onto the tolerance ring monitoring the mechanical resistance remaining compliant and the slope exceeding a maximum predetermined value; and
- (c2) seating the head stack assembly adjacent a basedeck of the basedeck assembly forming the head disc assembly.

8. (original) The method of claim 2 in which the releasing step (d) comprises:

- (d1) verifying a radial displacement of radially disposed positionable gripper sections with a potentiometer confirming disengagement of the radially disposed positionable gripper sections from the head stack assembly;
- (d2) retracting the robotic assembly from communication with the head disc assembly; and
- (d3) releasing the head disc assembly from the head stack installation tool.

9. (original) The method of claim 3 wherein the computer further communicating with a display and wherein the physical characteristics of the head disc assembly and the physical characteristics of the head stack assembly are incompatible, the directing step (a) further comprises:

- (a5a) displaying the occurrence of the incompatibility between the head stack assembly and the head disc assembly on the display; and
- (a6a) aborting the installation process.

10. (original) The method of claim 4 wherein the computer further communicating with a display and wherein the measurement of radial displacement of the radially disposed positionable gripper sections is inconsistent with the radially disposed positionable gripper sections engaging the beveled pick and place member of the head stack assembly, the measuring step (a) further comprises:

- (a9a) directing the end effector assembly to move the radially disposed positionable gripper sections and the pair of opposing positionable flex connector grippers to disengage the beveled pick and place member and the flex connector body of the head stack assembly;
- (a10a) measuring the radial displacement of the radially disposed positionable gripper sections with the potentiometer to confirm the radial displacement of the radially disposed positionable gripper sections as consistent with disengagement from the beveled pick and place member;
- (a11a) commanding the robotic assembly to retract the end effector assembly from a nesting position;

- (a12a) displaying the occurrence of the inconsistency between the measurement of radial displacement of the radially disposed positionable gripper sections and engagement of the beveled pick and place member of the head stack assembly by the radially disposed positionable gripper sections on the display; and
- (a13a) aborting the installation process.

11. (original) The method of claim 10 wherein the installation force magnitude is a dynamic force threshold F derived from a relation $(F = f(p) \pm (x))$, where $f(p)$ is a profile of force as a function of position and x is a scalar value, the rate of change of installation force magnitude is a dynamic slope V determined by a slope derived from a relation $V = (f_n - f_{n-1}) / (p_n - p_{n-1})$ at time $(t_{n-1}$ and $t_n)$, where f_n represents the mechanical resistance occurring at a point in time t_n while at a position of engagement p_n and f_{n-1} represents the mechanical resistance occurring at a preceding point in time t_{n-1} while at a preceding position of engagement p_{n-1} and wherein the mechanical resistance encountered by the head stack assembly engaging the basedeck is in non-compliance with the dynamic force threshold F and the dynamic slope V remaining compliant with predetermined values, in which the seating step (c) comprises:

- (c1a) directing the robotic assembly to apply a tensile force on the head stack assembly to disengage the head stack assembly from the tolerance ring;
- (c2a) compelling the robotic assembly to remove the head stack assembly from the head disc assembly and retract the end effector assembly from the basedeck assembly;
- (c3a) reading position data of the horizontal slide and the vertical slide;
- (c4a) dispatching the robotic assembly to align of the head stack assembly adjacent

- the nesting position;
- (c5a) enjoining the end effector assembly to disengage the radially disposed positionable gripper sections from the beveled pick and place member of the head stack assembly;
- (c6a) measuring the radial displacement of the radially disposed positionable gripper sections with the potentiometer;
- (c7a) reading the measured displacement of the radially disposed positionable gripper sections to confirm disengagement of the radially disposed positionable gripper sections with the beveled pick and place member of the head stack assembly;
- (c8a) commanding the robotic assembly to retract the end effector assembly from the nesting position;
- (c9a) displaying the occurrence of the noncompliance of force to distance ratio with the predetermined values on the display; and
- (c10a) aborting the installation process.

12. (previously presented) The method of claim 10 wherein the rate of change of installation force magnitude is a dynamic slope V determined by a slope derived from a relation $V = (f_n - f_{n-1}) / (p_n - p_{n-1})$ at time $(t_{n-1}$ and $t_n)$, where f_n represents the mechanical resistance occurring at a point in time t_n while at a position of engagement p_n and f_{n-1} represents the mechanical resistance occurring at a preceding point in time t_{n-1} while at a preceding position of engagement p_{n-1} , and wherein the dynamic slope V determined by the equation $V = (f_n - f_{n-1}) / (p_n - p_{n-1})$ lapses compliance with predetermined values, the seating step (c) further comprises:

- (c1b) directing the robotic assembly to apply a tensile force on the head stack assembly to disengage the head stack assembly from the tolerance ring;
- (c2b) compelling the robotic assembly to remove the head stack assembly from the head disc assembly and retract the end effector assembly from the basedeck assembly;
- (c3b) reading position data of the horizontal slide and the vertical slide;
- (c4b) dispatching the robotic assembly to align the head stack assembly adjacent the nesting position;
- (c5b) enjoining the end effector assembly to disengage the radially disposed positionable gripper sections from the beveled pick and place member of the head stack assembly;
- (c6b) measuring the radial displacement of the radially disposed positionable gripper sections with the potentiometer;
- (c7b) reading the measured displacement of the radially disposed positionable gripper sections to confirm disengagement of the radially disposed positionable gripper sections with the beveled pick and place member of the head stack assembly;
- (c8b) commanding the robotic assembly to retract the end effector assembly from the nesting position;
- (c9b) displaying the occurrence of the noncompliance of force to distance ratio with the predetermined values on the display; and
- (c10b) aborting the installation process.

13. (original) The method of claim 1 wherein the installation force magnitude is a dynamic force threshold F derived from a relation $(F = f(p) \pm (x))$, where $f(p)$ is a profile of force as a function of position and x is a scalar value.

14. (original) The method of claim 1 wherein the rate of change of installation force magnitude is a dynamic slope V determined by a slope derived from a relation $V = (f_n - f_{n-1}) / (p_n - p_{n-1})$ at time $(t_{n-1}$ and $t_n)$, where f_n represents the mechanical resistance occurring at a point in time t_n while at a position of engagement p_n and f_{n-1} represents the mechanical resistance occurring at a preceding point in time t_{n-1} while at a preceding position of engagement p_{n-1} .

15. (original) The method of claim 13 wherein the rate of change of installation force magnitude is a dynamic slope V determined by a slope derived from a relation $V = (f_n - f_{n-1}) / (p_n - p_{n-1})$ at time $(t_{n-1}$ and $t_n)$, where f_n represents the mechanical resistance occurring at a point in time t_n while at a position of engagement p_n and f_{n-1} represents the mechanical resistance occurring at a preceding point in time t_{n-1} while at a preceding position of engagement p_{n-1} .

16. (previously presented) The method of claim 15, in which the directing step (a) comprises:

(a1i) reading position data of a horizontal slide and a vertical slide;

(a2i) directing alignment of an end effector assembly adjacent the head stack

assembly based on the horizontal slide and the vertical slide position data;

(a3i) enjoining radial displacement of radially disposed positionable gripper sections

and lineal movement of a pair of opposing positionable flex connector grippers to engage a beveled pick and place member and a flex connector body of the head stack assembly.

17. (original) The method of claim 16 in which the directing step (a) further comprises:

- (a4i) removing of the head stack assembly from a nesting position of the head stack installation tool; and
- (a5i) aligning of the end effector assembly adjacent a head stack assembly post of the basedeck assembly.

18. (previously presented) The method of claim 17 in which the determining step (b) comprises:

- (b1i) engaging a tolerance ring supported by a head stack assembly post of the basedeck assembly;
- (b2i) pressing the head stack assembly onto the tolerance ring using the robotic assembly;
- (b3i) measuring the distance traveled by the head stack assembly relative to the head stack assembly post and a load cell to measure an amount of mechanical resistance imparted on the head stack assembly; and
- (b4i) calculating the mechanical resistance encountered by the head stack assembly engaging the basedeck and the dynamic slope by dividing the difference in the measured distance traveled between two points along the installation path into the difference in mechanical resistance encountered by the head stack

assembly between the same two points during the same period of time.

19. (previously presented) The method of claim 18 wherein the mechanical resistance encountered by the head stack assembly engaging the basedeck complies with the dynamic force threshold F and the dynamic slope V remaining compliant with predetermined values, in which the seating step (c) comprises:

- (c1) continuing pressing the head stack assembly onto the tolerance ring monitoring the mechanical resistance remaining compliant and the slope exceeding a maximum predetermined value; and
- (c2) seating the head stack assembly adjacent a basedeck of the basedeck assembly forming the head disc assembly.

20. (canceled)

21. (previously presented) A method for inserting a first member onto a second member, comprising:

pressing the first member into mating contact along the second member in a first direction from a first position to a second position while measuring a sequence of resistance force values indicative of intermediary resistance force encountered by the first member and a corresponding sequence of position displacement values indicative of intermediary positions of the first member with respect to the second member between the first and second positions; during the pressing step, successively comparing the sequence of resistance force values to a force as a function of position curve threshold having threshold

values that vary with respect to the intermediary positions of the first member; and

aborting the pressing step when at least one of the resistance force values from said sequence exceeds the force as a function of position curve threshold.

22. (previously presented) The method of claim 21, further comprising completing the pressing step when the sequence of resistance force values lies within the force as a function of position curve threshold.

23. (previously presented) The method of claim 21, in which the pressing step comprises dispatching a robotic assembly to pick the first member, align the first member adjacent the second member, and press the first member into mating contact along the second member.

24. (previously presented) The method of claim 21, in which the first member is pressed into mating contact along the second member by steps comprising:

dispatching a pick and press tool to grip and align the first member relative to the second member;

aligning the first member adjacent the second member with the pick and press tool;

and

applying a continuous load on the first member with the pick and press tool while pressing the first member into mating contact along the second member.

25. (previously presented) The method of claim 23, in which the mechanical resistance as a function of position curve is empirically derived by measuring the mechanical resistance encountered by the first member while being pressed into mating contact along the second member at each of a plurality of predetermined increments of distance encountered by the first member while the first member travels along a distance of the second member.

26. (previously presented) The method of claim 25, in which the threshold of the mechanical resistance as a function of position curve is determined by applying a tolerance around each mechanical resistance measured at each predetermined increment of distance of the plurality of predetermined increments of distance encountered by the first member traveling along the distance of the second member.

27. (previously presented) The method of claim 26, in which the tolerance applied around each mechanical resistance measured at each predetermined increment of distance encountered by the first member traveling along the distance of the second member is substantially plus and minus 5% of the mechanical resistance measured at each predetermined increment of distance encountered by the first member traveling along the distance of the second member.

28. (previously presented) The method of claim 27, in which the first member is a head stack assembly and the second member is a tolerance ring supported by a head stack assembly post of a basedeck assembly.

29. (previously presented) The method of claim 28, in which the first member is pressed into mating contact along the second member by steps comprising:

- dispatching a robotic assembly to pick and press the head stack assembly into mating contact along the tolerance ring;
- applying a continuous load on the head stack assembly with the robotic assembly while pressing the head stack assembly into mating contact along the tolerance ring thereby causing the head stack assembly to travel the distance of the tolerance ring; and
- measuring the mechanical resistance encountered by the head stack assembly traveling along the distance of the tolerance ring at each of the predetermined increments of distance of the plurality of predetermined increments of distance encountered by the head stack assembly traveling along the distance of the tolerance ring.

30. (currently amended) A disc drive comprising a head disc assembly with a basedeck supporting a head stack assembly, the head stack assembly inserted onto the basedeck by steps for inserting a first member onto a second member used in qualifying the disc drive based on an observed mechanical resistance to the inserting.

31. (currently amended) The disc drive of claim 30, ~~in which the steps for inserting a first member onto a second member comprise:~~

- ~~pressing the first member into a mating contact along the second member in a first direction from a first position to a second position while measuring a sequence of resistance force values indicative of intermediary resistance force~~

~~encountered by the first member and a corresponding sequence of position displacement values indicative of intermediary positions of the first member with respect to the second member between the first and second positions; during the pressing step, successively comparing the sequence of resistance force values to a force as a function of position curve threshold having threshold values that vary with respect to the intermediary positions of the first member; and aborting the pressing step when at least one of the resistance force values from said sequence exceeds the force as a function of position curve threshold wherein the steps for inserting are characterized by measuring a resistance force opposing an inserting force in relation to a displacement of the first member relative to the second member.~~

32. (currently amended) The disc drive of claim 30, ~~in which the steps for inserting a first member onto a second member comprise:~~

~~directing a robotic arm to pick and place the head stack assembly into the basedeck assembly;~~

~~determining compliance of mechanical resistance encountered as the head stack assembly engages the basedeck in relation to installation force magnitude and rate of change of installation force magnitude, over time and position;~~

~~seating the head stack assembly onto the basedeck assembly forming the head disc assembly, upon determining mechanical resistance and slope compliance; and releasing the head disc assembly from the head stack installation station 31 wherein the steps for inserting are characterized by comparing the observed resistance~~

forces at a plurality of displacement values to a predetermined threshold for qualifying the disc drive.

33. (previously presented) The disc drive of claim 31, in which the first member is the head stack assembly, and in which the second member is the basedeck.